

Work Order ID 78783

78783

Page 1

January-16-12 7:41:37 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop ***NS2***

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/16 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100 0.00

100

DOCUMENT CONTROL

DC

Memo 0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/2/07

MLJ 12/03/06

10

110 0.00

110

Large Fab

Large Fab

Memo 0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 119785

3-Grind End Plate flush 119712

Ac 12/02/14

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Approvals:

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

10 BL 12 2 22

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 120169

6-Grind End Plate flush

7-Install last rivet as per Dwg.

12.02.28
Ae 12/02/23

X10 ∅

W/O:		WORK ORDER CHANGES					
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NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

Handwritten: NO Re

Handwritten: 10X M-L 12/03/05 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long RH
 Start Date: 16/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:15</u>								
	OVEN TEMPERATURE: <u>3200°F</u>								
	FINISH TIME: <u>12:45</u>								
230	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.00							
Quality Control									

10X M-1 12/03/05
 RH

10 BR 123-5.

10 RM d 12/03/05

M120222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

12/3/12 54 (10) [Signature]

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

8/17/03/07

[Signature]

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: [Signature]

6/12/3/5 (10) [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 12/03/08

✓ 12-03-08

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 78783

78783

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	30.0000	1	10			

D3272-1

Step

**

12.02.13

Location	Loc Qty	Loc Code
ST	-10	
WA	40	
77650	10	
77651	10	
77653	10	

D3067-1

Manufactured No

110

Each

127.0000

1

10

D3067-1

End Plate

**

12.02.13

Location	Loc Qty	Loc Code
WA	120	
78022	120	
WA016	7	
67582	2	
68214	1	
76179	4	

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Work Order ID: 78783

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No

110 Each

78.0000 2 20

D3219-1

Plate

**

12.02.13

Location

Loc Qty

Loc Code

WA016 *B78763* 78
73410 12
76226 14
77674 52

20

D3066-1 Manufactured No

180 Each

96.0000 2 20

D3066-1

Spacer

**

~~B79419~~ (x7) Ae 12/02/23
~~B78797~~ (x3)

Location

Loc Qty

Loc Code

WA 70
77564 70
WA015 26
76180 26

B79729 → (x20)

MS20600-AD4W4 Purchased No

180 Each

2,386.000 16 160

MS20600-AD4W4

Rivets

**

B120308 (160) Ae 12/02/23

Location

Loc Qty

Loc Code

ST321 2381
116188 59
117364 253
117601 200
117885 195
118840 1089
119860 30
119883 555
WA018 5
116712 5

January-16-12 7:41:41 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180 Each

12.0000 1 10

D3065-041

Step Leg Assembly Hi

**

B79419 (x7) Ae 12/02/23
B78797 (x3)

Location

Loc Qty

Loc Code

WA

12

66149

0

77054

12

D3067-1

Manufactured No

180 Each

127.0000 1 10

D3067-1

End Plate

**

12.02.28

Location

Loc Qty

Loc Code

WA

120

78022

120

WA016

7

67582

2

68214

1

76179

4

AN3-35A

Purchased No

250 Each

243.0000 2 20

AN3-35A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST353

243

119449

43

120187

200

D3235-1

Manufactured No

250 Each

47.0000 2 20

D3235-1

Mounting Lug

**

B78787 12/13/2012

Location

Loc Qty

Loc Code

ST481

47

75547

47

SP

January-16-12 7:41:41 AM

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Page 3

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250 Each

11.0000

1 10 1

9

**

B77057

B78294

SP

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST481

11

76169

11

AN960JD416

NAS1149D0463J Purchased

No

250 Each

0.0000

16 160

**

M120644

SP

AN960.ID416

Washer

AN960JD516

NAS1149D0563J Purchased

No

250 Each

0.0000

4 40

**

M12614

SP

AN960.ID516

Washer

AN5-36A

Purchased

No

250 Each

245.0000

2 20

**

SP

SP

AN5-36A

Bolt

Location

Loc Qty

Loc Code

ST340

245

119641

45

120187

200

D2618

Manufactured No

250 Each

152.0000

2 20

**

B78537

12/3/7

SP

D2618

Bushing

Location

Loc Qty

Loc Code

ST012

152

76130

52

77563

100

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250 Each

72.0000

D2230-3

Lug

** 4

***40**
~~B78593~~

slc sp

B78593

Location

Loc Qty

Loc Code

ST480

72

53881

4

70973

1

75546

1

76642

66

D2856-400

Manufactured No

250 f

113.7673

1.2

12.10.100

D2856-400

Abraison Strip

**

B77551

slc sp

Location

Loc Qty

Loc Code

ST409

113.767258

63735

0.6696

68076

0.3149

71164

21.66

73491

91.122758

2x

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

5,839.000

2

20

MS21042L3

cut

**

12/3/7

10

SP

Location

Loc Qty

Loc Code

ST300

5839

117441

16

117885

32

118451

5

118927

3

119017

5309

119075

474

20

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Parent Item Name: Heli-Access-Step, Long RH

78783

D350-591-312

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased No

250 Each

1,478.000 8

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

1478

119449

478

120187

1000

MS21042L5 Purchased No

250 Each

2,018.000 2

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

2018

116105

5

116548

43

117611

50

118179

420

119109

1500

MS21042L4 Purchased No

250 Each

7,507.000 8

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

7507

117441

67

117601

342

118451

133

119017

1965

119075

5000

AN960JD10. NAS1149D0363J Purchased No

250 Each

0.0000 4

AN960JD10

Washer

**

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DESIGN <i>90</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

3-8-03-1405
12/01/16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

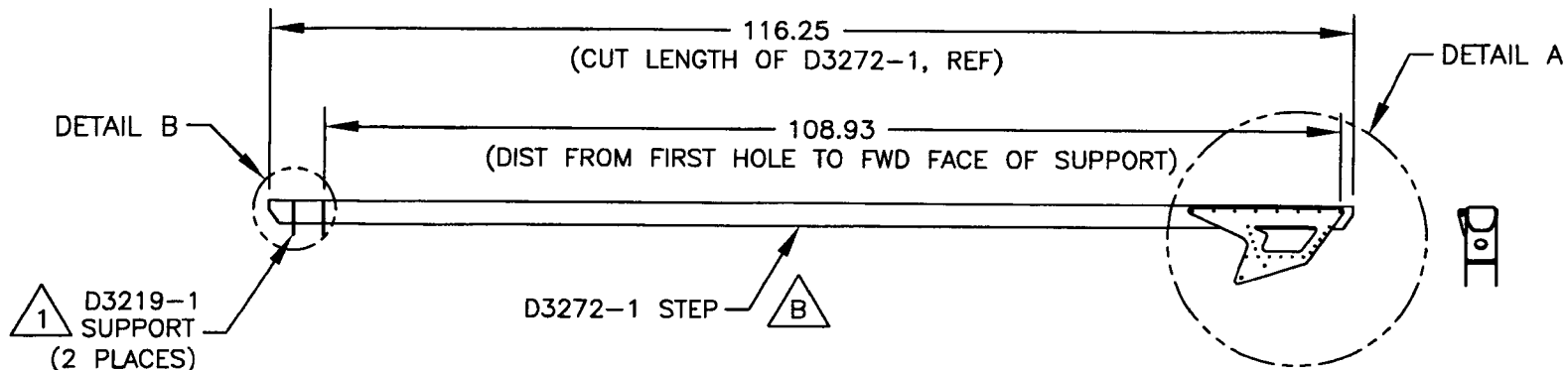
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

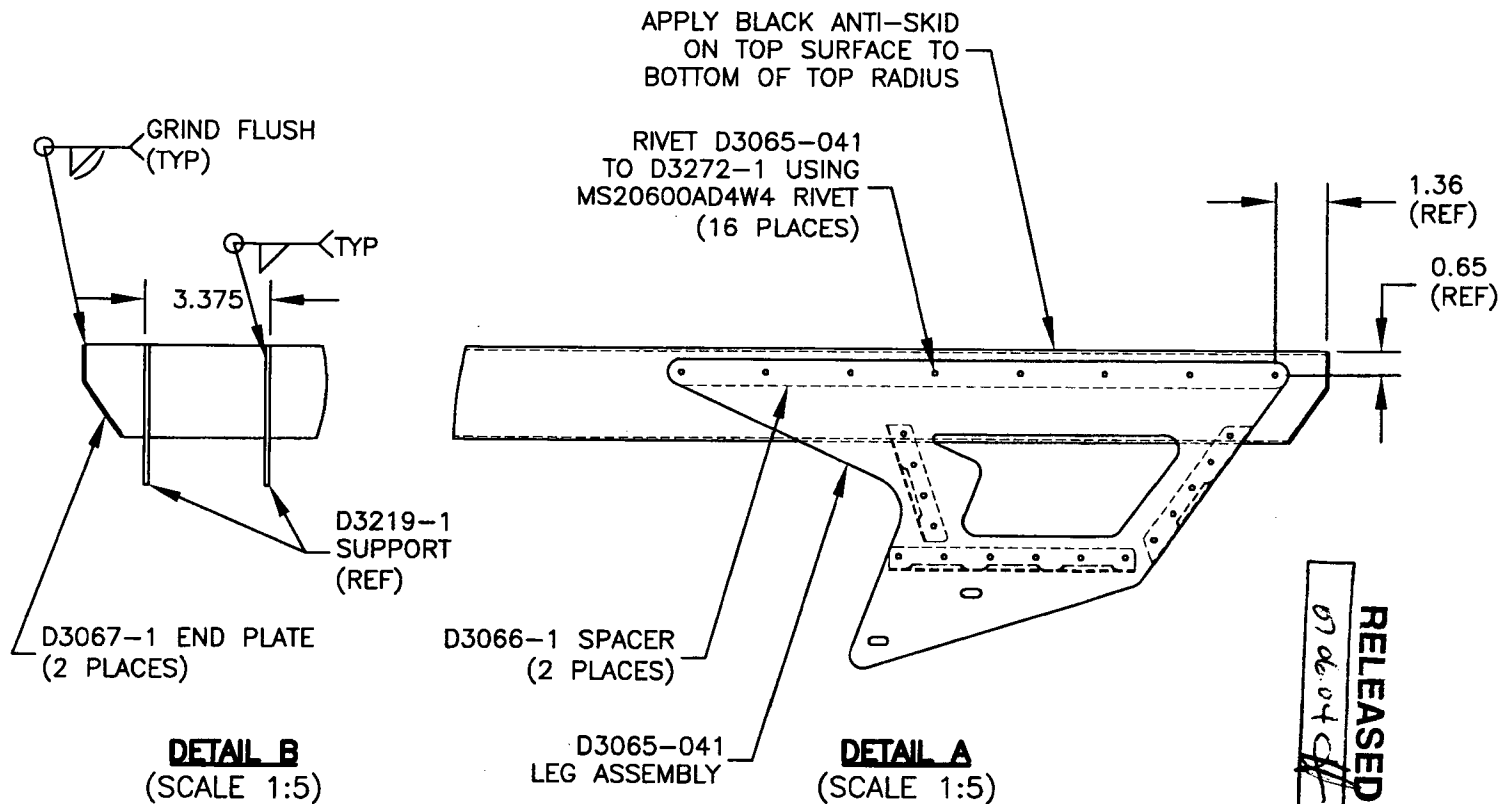
DART

DESIGN	q	DRAWN BY	J	DART AEROSPACE LTD
CHECKED	CE	APPROVED	J	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

78783



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

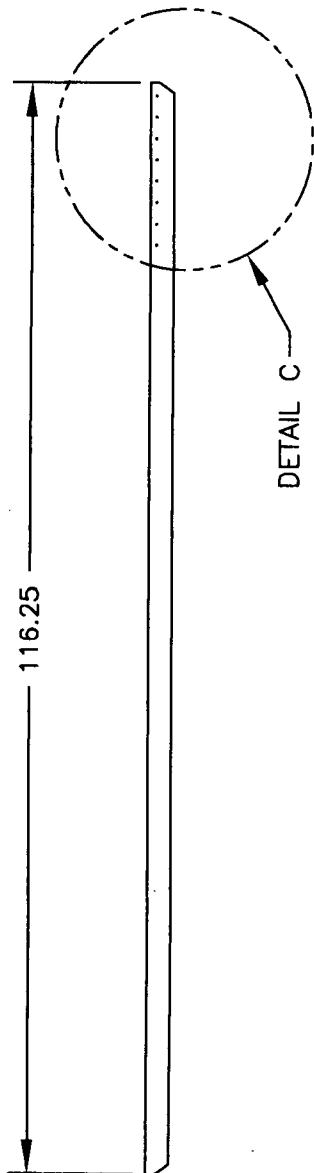
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



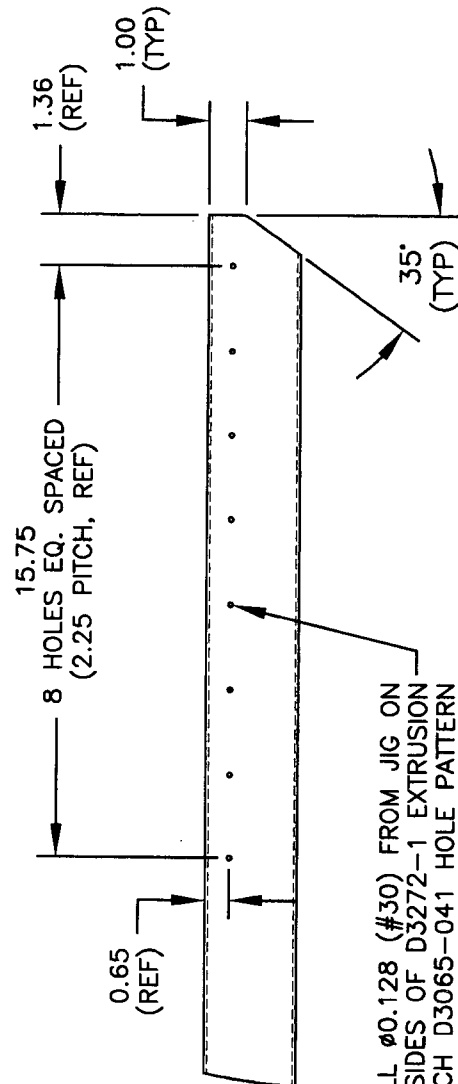
DESIGN 4P	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 [Signature]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**

Date: 08.10.06